

37

order 11505



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6796941-20
Job Sheet 188412



102nd

Part No: RB6796941-20

Job Qty: 5 pcs 9 pcs.

Part Name: Punch



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6796941-20 Rev. F IPP Rev. B 18.08.20 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-154 - 1	5 pcs	3/8/19	3/8/19	0.25	1.67	SL-154 - 1		19/02/12
130	QC 2	5 pcs	3/8/19	3/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		19/02/12
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

140 QC 8	5 pcs	3/8/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	Y.e 19-02-19
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
170 Outsource - 12 - Black Oxide	5 pcs	3/8/19	0.00 0.00	GROUP A1tech	CT 19-02-19
180 Packaging 2-1 - Receive - B4B	5 pcs	3/8/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 6	5 pcs	3/8/19	0.00 0.00	QC 6 - 38	

				QC 6 - 42	
				QC 6 - 9	DAS
				QC 6 - 68	FEB 22 2019
				QC 6 - 61	9-89
200	Packaging 3-1 - Stock - B4B	5 pcs	3/8/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
210	QC 21 - FG	5 pcs	3/8/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

Part Op 120 - SL-154 (MORI SL-154 LATHE) 1-Machine as per folio FC588 FOLIO REV: _____ DWG REV: _____
 Descriptions: _____ 2-Deburr
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 170 - -Issue P/O to GROUPE ALTECH; PO 04265 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Stress Proof -Certificate of Conformity is required
 180 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs) Receive
 190 - (QC6- All purchased or subcontracted products)
 200 - (Identify as per dwg & Stock Location: _____) Identify and Stock
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R1.250	MT-1144-R1.375	AISI 1144 Stressproof Round Bar 1.250"	.1605 ft (.0321 ea)	120-SL-154 - 1
			404	5039768

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-SL-154 - 1	MT-1144-R1.250	0	2	0
MAT009-N				
Part Specifications				
Specifications could not be found.				

Plex 1/25/19 8:20 AM Dart.Hadley.Shannon



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RB6796941-20
Job Sheet 188412



Part No: RB6796941-20

Job Qty: 5 ea

Part Name: Punch



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6796941-20 Rev. F IPP Rev. B 18.08.20 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	3/8/19	3/8/19	0.00	0.00	Start Up Machining-4		
120	Mori Seiki	5 pcs	3/8/19	3/8/19	0.25	1.67	SL-154		
130	QC	5 pcs	3/8/19	3/8/19	0.00	0.00	QC2 Machining-5		
140	QC	5 pcs	3/8/19	3/8/19	0.00	0.00	QC8 Machining-5		
170	Outsource	5 pcs	3/8/19	3/8/19	0.00	0.00	Outsource12		
180	Packaging	5 pcs	3/8/19	3/8/19	0.00	0.00	Packaging2		
190	QC	5 pcs	3/8/19	3/8/19	0.00	0.00	QC6		
200	Packaging	5 pcs	3/8/19	3/8/19	0.00	0.00	Packaging3-2		
210	QC21-FG	5 Ea	3/8/19	3/8/19	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FC 588 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Descriptions: ~~140 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG~~

170 - -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Stress Proof -Certificate of Conformity is required

180 - Receive

200 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R1.250	AISI 1144 Stressproof Round Bar 1.250"	.1605 ft (.0321 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-1144-R1.250	0	2	0

MAT009-N

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

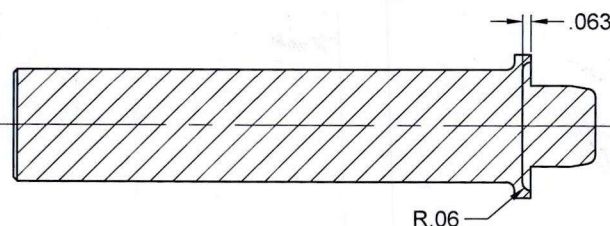
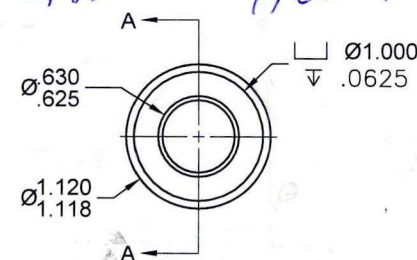
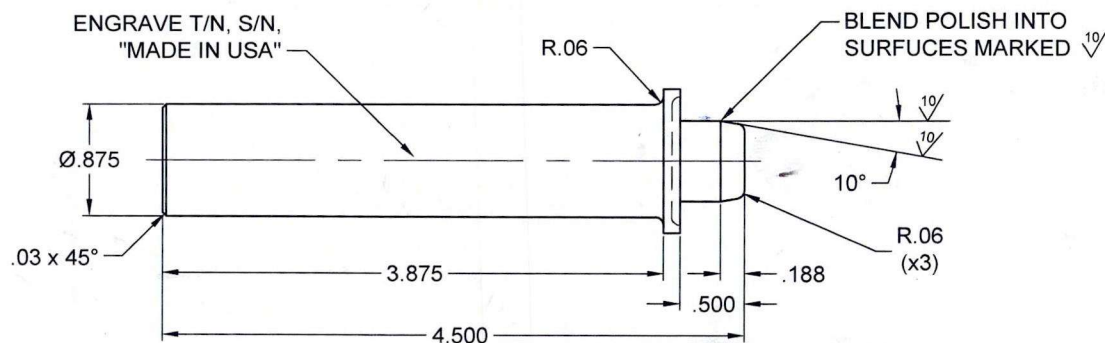
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐ _____					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
F	MADE INDIVIDUAL TOOL DWG. FROM KIT PER E.B.	7/15/11	RJC	RW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 188412 M 1901-09



SECTION A-A

(-20)
PUNCH

NOTES

- ALLISON T63-A-5 ACCESSORY GEARBOX.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
				1	PUNCH	SP	Ø1-1/4 x 4-5/8	

RED BARN MACHINE	
PUNCH	
DWG NO. RB6796941-20	REV F
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XX ± .005 FRACTIONS ± 1/32 ANGLES ± 5°	
DRAWN BY: COLE APPROVED: D. West HEAT TREAT: BLACK OXIDE FINISH: BLACK OXIDE SPEC:	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7-17-00
SHEET 1 of 1	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S153099



Part: RB6796941-20

Job No: 188412

Serial No/Batch: S153099

Revision: F

Inspector:

Exp Date:

Instructions:

Date: 02/12/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042652



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042652
PO Date: 2/19/19
Due Date: 2/27/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	188412	RB6796941-20	Punch -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Stress Proof -Certificate of Conformity is required	Firmed - X9		2/27/19	9 pcs	0 pcs	9 pcs	\$6.3157894/pcs	\$56.84
2	189448	RBT18524-1	Base -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed - X10		2/27/19	10 pcs	0 pcs	10 pcs	\$6.3157894/pcs	\$63.16

Grand Total: \$120.00



Dart Aerospace Ltd.
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K6A 1K7
Canada

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PURCHASE ORDER PO042652



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/20/19 10:51 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017013- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Feb-2019		SPARTAKOS BOUNTOURIS		042652				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB6796941-20 Rev.	RB6796941-20 BLACK OXIDE MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS OIL	BLACK-OXIDE CH	9	9	0	0	0
2	RBT185254-1 Rev.	RBT185254-1 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS OIL	BLACK-OXIDE CH	10	10	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.